

apart. The immobilizing device 60 is then retracted so that the chassis frame 10 can be advanced out of the workstation.

Kindly replace the section "ABSTRACT OF THE DISCLOSURE"
beginning at line 1 of page 28 and ending at line 19 of page 28 with the following:

ABSTRACT OF THE DISCLOSURE

~~An apparatus and~~ A method for finding and immobilizing a vehicle chassis frame in its free state ~~atop a frame fixture so as to establish a net datum position of the chassis frame for enabling to form~~ a net datum position feature to be fabricated in a location ~~net to the fixture and in the design-intent position on the chassis frame. The apparatus does not compressingly clamp any portion of the chassis frame in order to avoid deforming or displacing the chassis frame and to avoid building stress into the chassis frame or incurring springback of the chassis frame. The chassis frame is interposed~~ positioned between a pair plurality of opposed pads ~~used for contacting opposite portions of the chassis frame. A work support connects to each of the opposed pads for advancing the~~ The opposed pads are advanced from a retracted position to an advanced position to find ~~opposite portions of the chassis frame. The advancing device advances the pair of opposed pads into contact with engage the chassis frame without measurably displacing the chassis frame despite the tolerance variations such that there is minimal displacement or deformation thereof.~~ Once the opposed pads find their respective ~~opposite~~ reference contact surfaces on the chassis frame, a locking mechanism is provided for locking the pair of opposed pads in place in the advanced position so as to immobilize the chassis frame therebetween. Subsequently, a

forming and piercing mechanism may be used to fabricate locating features net to the frame fixture and in design-intent position on the chassis frame.